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DART AEROSPACE LTD	Work Order :	21914
Description: Console Side RH (407 Hi-Slope)	Part Number:	D2604-2
Note: Issue with Part Number D2604-1		
Drawing: D2604 Rev. A1	Qty:	9

04.11.17

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue W/O		04.11.17
2	CNC CELL / METAL	Cut Blank per template DT 8247 Note: 1 Blank makes: D2604-1(Qty: 1), D2604-2(Qty: 1) Material: .040 - 2024-T3 Batch B15919	EC	04.11.22
3	HAAS	Machine per folio D2604	qml	04.11.23
4	QC	Inspect Level 2	qml	04.11.23
5	QC	Inspect Level 8	EC	04.11.24
6	METAL	Form per Dwg D2604	2	04.12.09
7	QC	Inspect Level 5	ML	04.12.09
8	FINISHING	Acid etch & alodine as per QSI 005	2	04.12.09
9	STORES	Identify and stock	ml	04-12-13
10	EXPEDITING	Close W/O Inspect level 21 Cost / part 20.13 SUR 04/12/14	ML	05.01.13

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.25	Added Inspection Levels, Jig numbers	DM	
D	02.06.05	Added alodine finish TSR 1290	NG	

36 GA deburr

RELEASED

02/06/05

ml

04-11-24

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
04-11-24	36	Permanent change the 36 - debur - must be on the front	<i>[Signature]</i>	04.12.21	N/A	<i>[Signature]</i> perman	<i>[Signature]</i> 01/12/15

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
04-11-24 04-11-24	36 36	Found 1X D2604-1 Base Kink	<i>[Signature]</i> 04-11-24	destroy it	<i>[Signature]</i> 04-11-24	<i>[Signature]</i> 01-12-15	<i>[Signature]</i> perman	<i>[Signature]</i> 01-12-15
		↑ NOTE S/B. <u>D2604-1</u> <u>See w/o</u> 21913.						

Part No: D2604-2 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/01/13

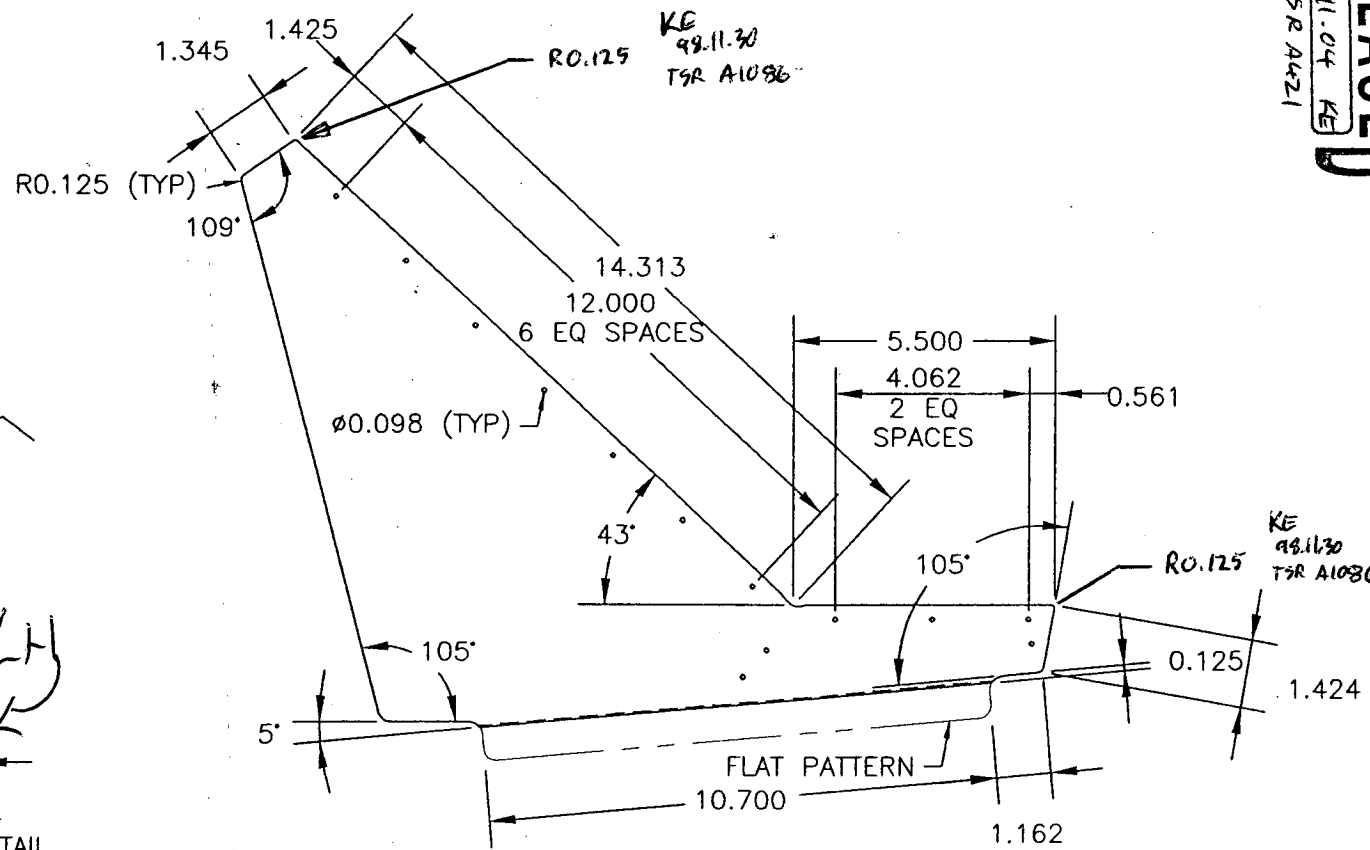
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART



RELEASED
97.11.04 KE
TSR A421

DESIGN	KE	DRAWN BY	bu	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	KE	APPROVED	KE	
DATE	97.10.24	TITLE	CONSOLE SIDE	REV. A
		DRAWING NO.	D2604	SHEET 1 OF 1
		DATE	97.10.24	SCALE
			02.06.04	1:4
			ADD FINISH	
			D2604 WAS D206-547-23/-24	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2604
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER DART Q51 Q55 4.1 **AI**
 D2604-1 SHOWN
 D2604-2 OPPOSITE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
WORK ORDER
NO. 21914

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2004
07:47 am

Work Order No	: 0021914	Department Code:	
Project Name	: D2604-2	Burden Flags	: NNNNNNNN
Project For	: WK450	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2604-2	Invoice Number	:
Description	: 407 Hi Console Side RH	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No.	:
Amount Req'd	: 10	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 11-16-04	Actual Margin	: 0.000%
Est Finish Date	: 12-04-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0. Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

